

60130-1220
01MMRA0210-CIP**AMENDMENTS TO THE SPECIFICATION:**

Please replace the following numbered paragraphs with the following rewritten paragraphs:

- [11] Figure 1 illustrates a flow chart of the present invention axle forming process 10. The process 10 is initiated with a hollow member 12. Preferably, the hollow member 12 is preferably a cylindrical tubular member 12 as indicated at step 20, but may also be a polygonal member as indicated in step 30. It is to be understood that hydroforming, stamping, rolling or swaging is a preferred method of forming, however, other methods may be used to form the hollow member 12. Although clearly not limited to only such sizes, a 3/8th inch wall thickness tube is provided to carry approximately 12,000 pounds; 9/16th inch wall thickness tube is provided to carry approximately 14,600 pounds; and 3/4th inch wall thickness tube is provided to carry approximately 18,000 pounds after the process sequence of the present invention.
- [15] The end 16 of the polygonal member 18 is formed, preferably by a stamping, rolling, swaging, hydroforming or pointing process, to provide a generally circular or frustoconical end 42 that is reduced in size relative to the hollow member 12 as indicated at step 40. Preferably, the end 16 is reduced to receive a desired end component, commonly a preformed king pin boss 52. Other forming methods and shapes will also benefit.